

Date: Thursday, 7/20/2006 1:04:40 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 212/205 HIGH AFT X-TUBE ASSEMBLY
Job Number	: 27988		
Estimate Number	: 10257		
P.O. Number	: N/A	Part Number	: D212664201
This Issue	: 7/20/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D212-664-241 REV B
First Issue	: 7/20/2006	Project Number	: N/A
Previous Run	: 27630	Drawing Revision	: B
		Material	: N/A
Written By	: <u> </u>	Due Date	: 8/30/2006
Checked & Approved By	: <u> </u>	Qty:	1 Um: Each
Comment	: Est Rev:E 04.02.16 Reformat K/DS		
	: Est Rev:F 06-03-29 Remove Comments on Pick List JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D212-664-201CHG002

2.0	D6006129	Crosstube material
-----	----------	--------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6006-129 Crosstube 25B66

Check OD = 3.250"; ID = 2.220"

BG 06-09-11

1

3.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
-----	------------	----------------------------



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA114

2-Turn first side as per Folio FA114

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-241.

BG 06-09-11

1

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
-----	-----	------------------------------



Comment: INSPECT ALL DIM TO DIM SHEET

BG 06-09-11

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 7/20/2006 1:04:40 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212/205 HIGH AFT X-TUBE ASSEMBLY

Job Number: 27988

Part Number: D212664201

Job Number:



Seq. #: Machine Or Operation: Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA114

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-241. BG 06-09-11 1

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

BG 06-09-11 1

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.G 06/09/11 1

8.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Polish entire outside surface of crosstube

2-Remove sand and plugs

3-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-241

Done At Seq. #13.0 Pm 06-10-30

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 within 24 hours of machining

M-B 06/10/13

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DD

6-10-13

11.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D212-664-241 using CNC bender program 212-af and Folio FT007

DD/EL 07/1/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 7/20/2006 1:04:41 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212/205 HIGH AFT X-TUBE ASSEMBLY

Job Number: 27988

Part Number: D212664201

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC6

DIMENSIONAL CHECK



207-01-10 (1)



Comment: DIMENSIONAL CHECK

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube as per Dwg D212-664-241 using drill Jig DT8550 & DT8551

2-Ream hole to finish size in tube as per Dwg D212-664-241 using drill Jig DT8550 & DT8551. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-241

207-01-15
DP/207-1-16 (1)

14.0

HAND FINISHING 1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 within 24 hours of bending and drilling

DP/HR 07/01/17

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

207-01-18 (1)

16.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038

Issue P/O: *2890*

LPI as per ASTM 1417 Level 2

Attach copy of NDT results to work order

C2070118 (1)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage Ensure copy of NDT results attached to work order.

07/01/19

18.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect for damage & ensure results are as per Dwg D212-664-241

207-01-22 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 7/20/2006 1:04:41 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212/205 HIGH AFT X-TUBE ASSEMBLY

Job Number: 27988

Part Number: D212664201

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

ml 07 01 25

①

2-Paint outside crosstube with White Imron as per QSI 005 4.2

ml 07 01 31

①

20.0

QC14

Inspect Spray Paint



Comment: Inspect Spray Paint

Then, Wrap in plastic bag to protect from scratches

07 02 01

21.0

D2856600

Abrasion Strip



Comment: Qty.: 0.8400 f(s)/Unit Total: 0.8400 f(s)

Pick:

Qty Part number Description Batch

2 D2856-600-1009 Abrasion Strip

B26650

ST 07 03 20

22.0

D29401

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2940-1

Support

B24367

ST 07 03 20

23.0

MS2192028

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-28

Clamp

17101684 / M102534

ST 07 03 20

24.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8582

2-Install supports and clamps as per Dwg D212-664-241. Torque clamps to 80-100 in lb.

ST 07 03 20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 7/20/2006 1:04:41 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212/205 HIGH AFT X-TUBE ASSEMBLY

Job Number: 27988

Part Number: D212664201

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

25.0

QC5

INSPECT WORK TO CURRENT STEP



70703.20 @

Comment: INSPECT WORK TO CURRENT STEP

26.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

27.0

D34281

Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Placard

Batch: *B 26249* ✓

28.0

AN640A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch: *M101697* ✓

29.0

AN641A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

Batch: *M101418* ✓

30.0

AN960JD616

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)

Washer

Batch: *M102829* ✓

31.0

MS21042L6

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Nut

Batch: *M100151* ✓

C/S 7/20/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 7/20/2006 1:04:41 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212/205 HIGH AFT X-TUBE ASSEMBLY

Job Number: 27988

Part Number: D212664201

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



07/03/21 (1)

Comment: INSPECT 100% KITS FOR COMPLETENESS

07/3/21 (1)

33.0

PACKAGING 1

PACKAGING RESOURCE #1



REV: B

Comment: HAND FINISHING RESOURCE #1

Identify and pack for shipping as per PPP D212-664-201

07/03/21 (1)

34.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

07/03/21 (1)

Job Completion



07/03/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	27988
Description: Crosstube Assembly (205/212 High Aft)		Part Number:	D212-664-241
Inspection Dwg: D212-664-241 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	0.200	+/-0.010	0.200				
	R0.063	+/-0.010	0.063				
	2.990	+0.005/-0.000	2.993				
	5.237	+/-0.030	5.237				
	2.600	+0.005/-0.000	2.603				
	2.686	+0.005/-0.000	2.689				
	2.770	+0.005/-0.000	2.774				
	2.854	+0.005/-0.000	2.858				
	2.938	+0.005/-0.000	2.941				
	3.021	+0.005/-0.000	3.026				
	3.133	+0.005/-0.000	3.138				
	3.179	+0.005/-0.000	3.184				
SIDE B	0.200	+/-0.010	0.200				
	R0.063	+/-0.010	0.063				
	2.990	+0.005/-0.000	2.992				
	5.237	+/-0.030	5.237				
	2.600	+0.005/-0.000	2.604				
	2.686	+0.005/-0.000	2.690				
	2.770	+0.005/-0.000	2.773				
	2.854	+0.005/-0.000	2.854				
	2.938	+0.005/-0.000	2.942				
	3.021	+0.005/-0.000	3.024				
	3.133	+0.005/-0.000	3.137				
	3.179	+0.005/-0.000	3.182				
	124.36	+/-0.020	124.36				

Measured by:	BC	Audited by:	J.G	Prototype Approval:	N/A
Date:		Date:	06/09/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue (P/O D412-664-201)	KJ/JLM	
B	06.03.09	Tolerance for 5.237 was +/-0.001	KJ/JLM	



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D212-664-241	REV. B SHEET 1 OF 3
DATE 05.02.04		TITLE CROSSTUBE ASS'Y (205/212 HI AFT)	SCALE NTS
A	00.12.12	NEW ISSUE	
B	05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED
05.06.09 [Signature]

Qty	Part Number	Description
X	D212-664-241	CROSSTUBE ASSEMBLY (205/212 HIGH AFT)
1	D6006-129	CROSSTUBE
2	D2940-1	SUPPORT
2	D2856-600-1009	ABRASION STRIP
4	MS21920-28	CLAMP

GENERAL NOTES:

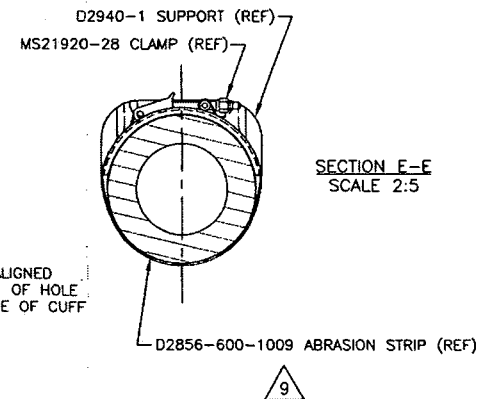
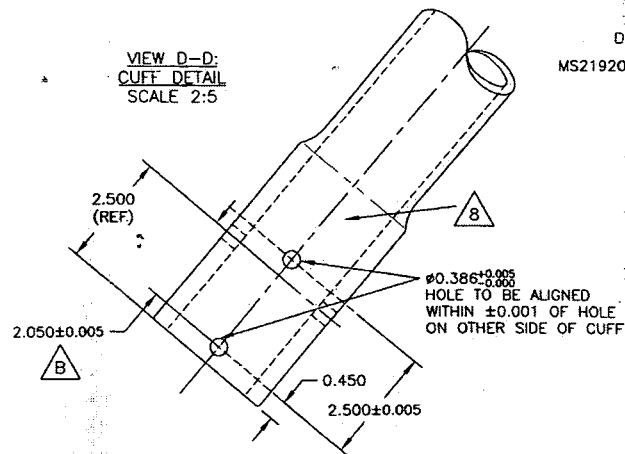
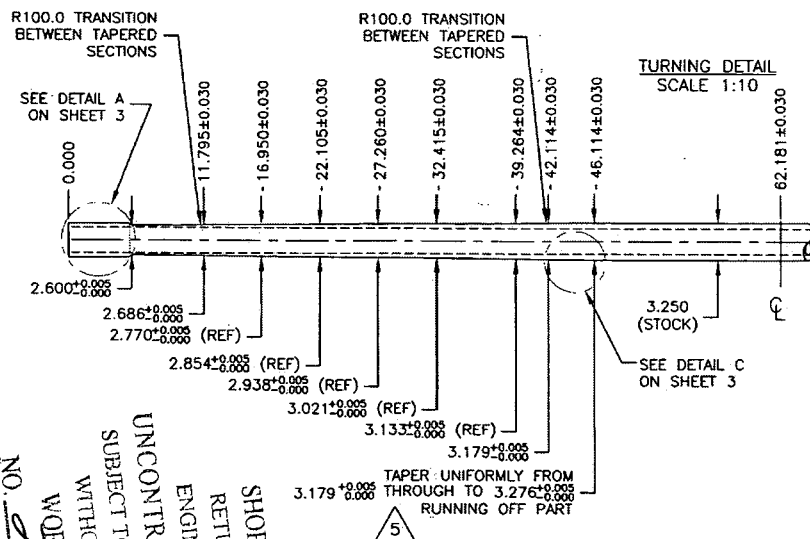
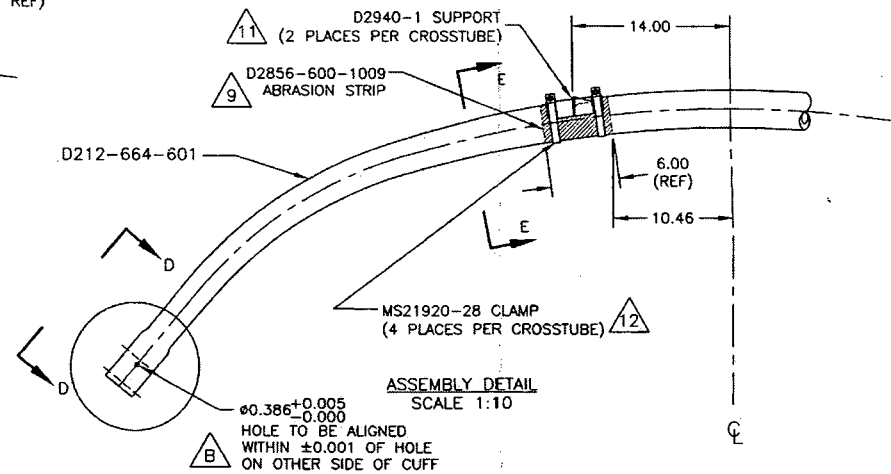
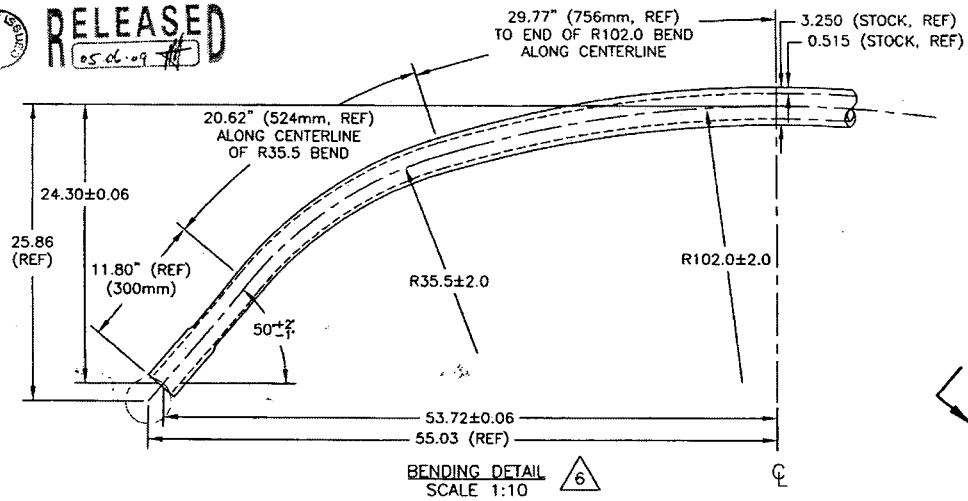
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) MATERIAL: MANUFACTURED FROM D6006-129
FINISHED LENGTH = 124.36 ± 0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 5 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-600-1009 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2940-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX 241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
NEXT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27988

Copyright © 2000 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

RELEASED
05.06.09



COPYRIGHT © 2000 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

DESIGN

CHECKED

DATE _____

05.02.04

DRAWN BY

APPROVED

DART

DART AEROSPACE LTD.
MISSISSAUGA, ONTARIO, CANADA

REV. B

DRAWING NO.
D212-664-241

SHEET 2 OF 3

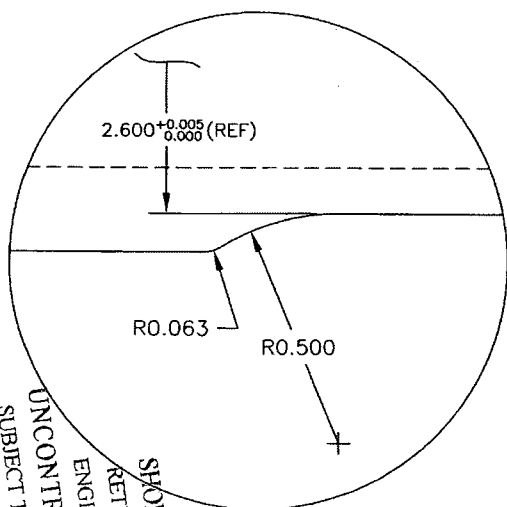
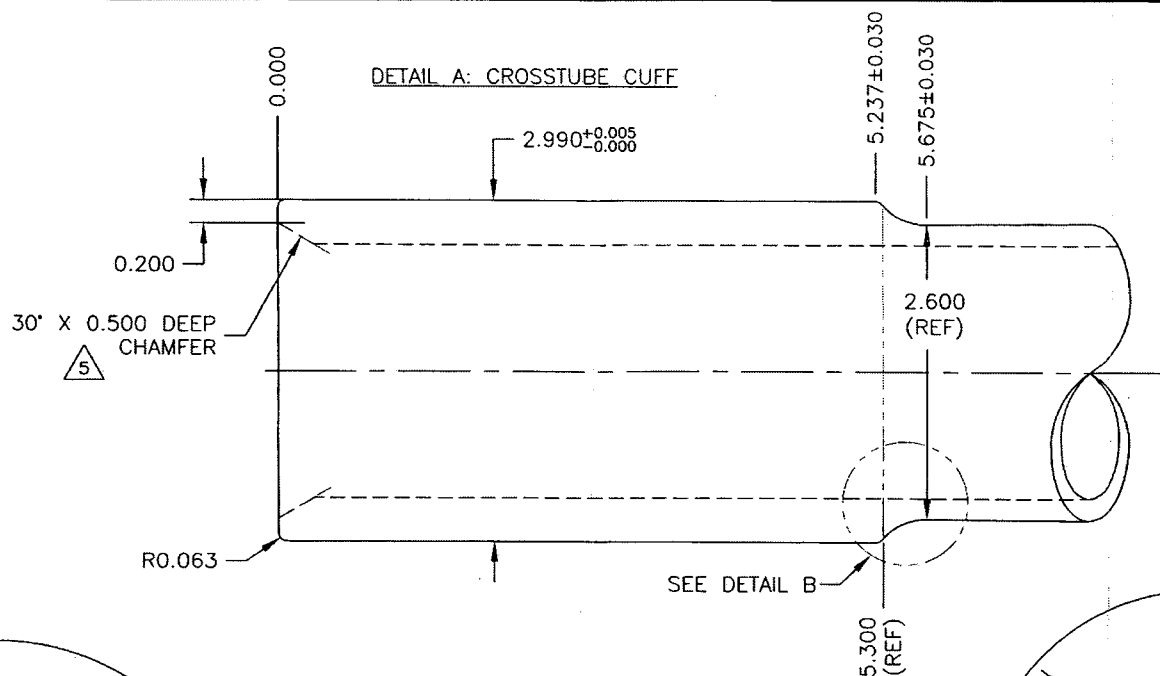
TITLE	SCALE
CROSSTUBE ASS'Y (205/212 HI AFT)	1:10

SCALE

1:10

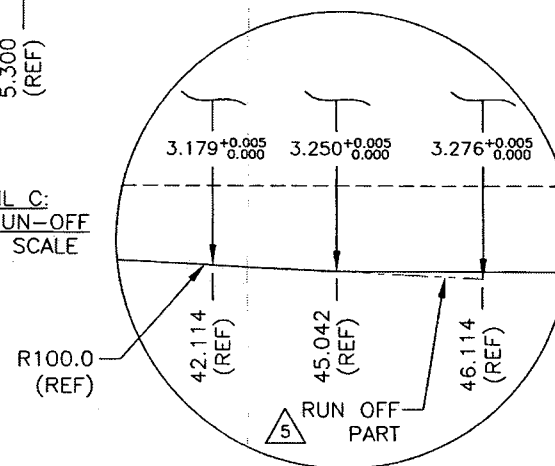
SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO ATTENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27988

RELEASED



DETAIL B: CUFF
TRANSITION
SCALE 4:1

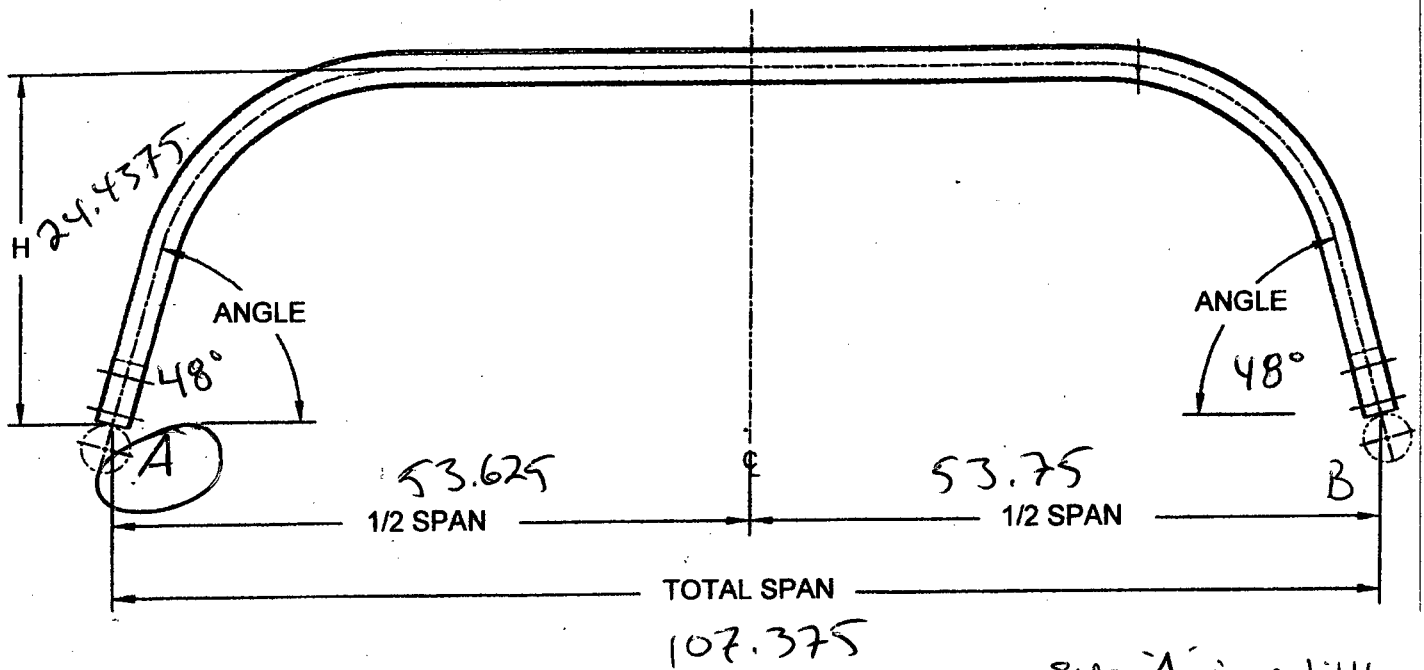
DETAIL C:
TAPER RUN-OFF
NOT TO SCALE



NO. 27988
WORK ORDER
WITHOUT NOTICE
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
ENGINEERING
RETURN TO
SHOP COPY

COPYRIGHT © 2000 BY DART AEROSPACE LTD.		DESIGN	DRAWN BY	DART DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		CHECKED FH	APPROVED PH	DRAWING NO. D212-664-241	REV. B SHEET 3 OF 3
DATE 05.02.04		TITLE CROSSTUBE ASS'Y (205/212 HI AFT)		SCALE 1:1	

Crosstube Bend Dimension Sheet



Side 'A' in a little on table.

PART NUMBER: 0212664201

BATCH NUMBER: 27988

DRAWING: 0212664241 REVISION: B

H: 24.3

1/2 SPAN: 53.72

TOTAL SPAN: 107.44

ANGLE: 50°

QC 15: [Signature]

DATE: 07-24-10

QTY: 1



HeathAir

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3
Tél.: (514) 636-1000 • Fax: (514) 636-0031

W.O. N° 35593

A.M.O. Number: 46/90

NON-DESTRUCTIVE TESTING REPORT

AIRCRAFT / COMPONENT INFORMATION

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG:

OPERATED BY:

BASED AT:

INSPECTION REQUIREMENTS

Carry out FPI of six (6) cross tubes (external surface) as per ASTM E-1417-05 and the Dart QSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty. (4) P/N D212-664-201 S/N's B28762, B27627, B27990 & B27988

Qty. (1) P/N D206-667-201 S/N B29095

Qty. (1) P/N D206-667-203 S/N B28978



RADIOGRAPHY



ULTRASONIC



PENETRANT



MAGNETIC PARTICLE



EDDY CURRENT

INSPECTION REPORT

Fluorescent penetrant inspection was performed in accordance with the above requirements on six (6) cross tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive)
Ardrox 970P25E Batch #04B503.

Six (6) cross tubes PASSED inspection.

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH
THE APPLICABLE STANDARDS OF AIRWORTHINESS

INSPECTED BY:

DATE January 18, 2007

INSPECTION STAMP(S) Not Required

CUSTOMER INFORMATION

CUSTOMER: Dart Aerospace

P.O. NUMBER

2890

ADDRESS:

CONTACT NAME:

LABOUR	@	\$
MATERIALS	@	
TRAVEL EXPENSES	@	GST
HOTEL EXPENSES	@	PST

INVOICE NO.

TOTAL \$

WHITE COPY - INSPECTION FILE • YELLOW COPY - CUSTOMER • PINK COPY - ACCOUNTANT

Date: Thursday, 7/20/2006 1:04:40 PM
User: Linda Lacelle

Process Sheet

35

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 27988
Estimate Number : 10257
P.O. Number :
This Issue : 7/20/2006 S.O. No. :
Prsht Rev. : NC
First Issue : 7/20/2006 Type : LANDING GEAR
Previous Run : 27630
Drawing Name : 212/205 HIGH AFT X-TUBE ASSEMBLY
Part Number : D212664201
Drawing Number : D212-664-241 REV B
Project Number : N/A
Drawing Revision : B
Material :
Due Date : 8/30/2006 Qty: 1 Um: Each
Written By :
Checked & Approved By : 06.07.21
Comment : Est Rev:E 04.02.16 Reformat K/DS
Est Rev:F 06-03-29 Remove Coments on Pick List JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D212-664-201CHG002

06.08.04

2.0 D6006129 Crosstube material



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6006-129 Crosstube

Check OD = 3.250"; ID = 2.220"

3.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA114

2-Turn first side as per Folio FA114

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-241.

4.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

REFERENCE ONLY